

ABSTRACT OF THE DISCLOSURE

A die for forming a work-piece having a complex geometry includes a die insert having an interior surface that defines a first portion of the complex geometry and a retainer ring that selectively engages the die insert. The retainer ring includes a circumferential interior surface that defines a second portion of the complex geometry. A punch insert that is slidably disposed in the retainer ring and includes a surface that defines a third portion of the complex geometry.